

Date: Wednesday, 7/11/2007 2:46:17 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 33468					
Estimate Number	: 10175					
P.O. Number	: <u>NA</u>		Part Number	: D2570		
This Issue	7/11/2007	S.O. No.	<u>NA</u>	Drawing Number	: D2570 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: <u>NA</u>		Type	: MACHINED PARTS		
Previous Run	: 32103		Drawing Revision	: B		
Written By	: <u>JO</u>		Material	: <u>NA</u>		
Checked & Approved By	: <u>07/07/07</u>		Due Date	: 7/31/2007		
Comment	: Est E 02.08.29 Re-format; Removed finishing; Material change K J est F 07.07.06 rev B dwg EC					
Qty: 500 Um: Each						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0750	303 Round Bar .75"
Comment: Qty.: 0.0810 f(s)/Unit Total : 40.4775 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch <u>105145</u> <u>07/20 07/08/08</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr and tumble <u>07/20 07/08/08</u> <u>600</u> <u>DSR 07/08/08</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>07/20 07/08/08</u> <u>600</u> <u>DSR 07/08/08</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>07/20 07/08/08</u> <u>500</u>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ <u>07/08/10</u> <u>500</u>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AD Date: 07/08/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(500)

Comment: FINAL INSPECTION/W/O RELEASE

Dar/08/10

Job Completion



207/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33468
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570	Rev: A-B 01 07-07-11	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

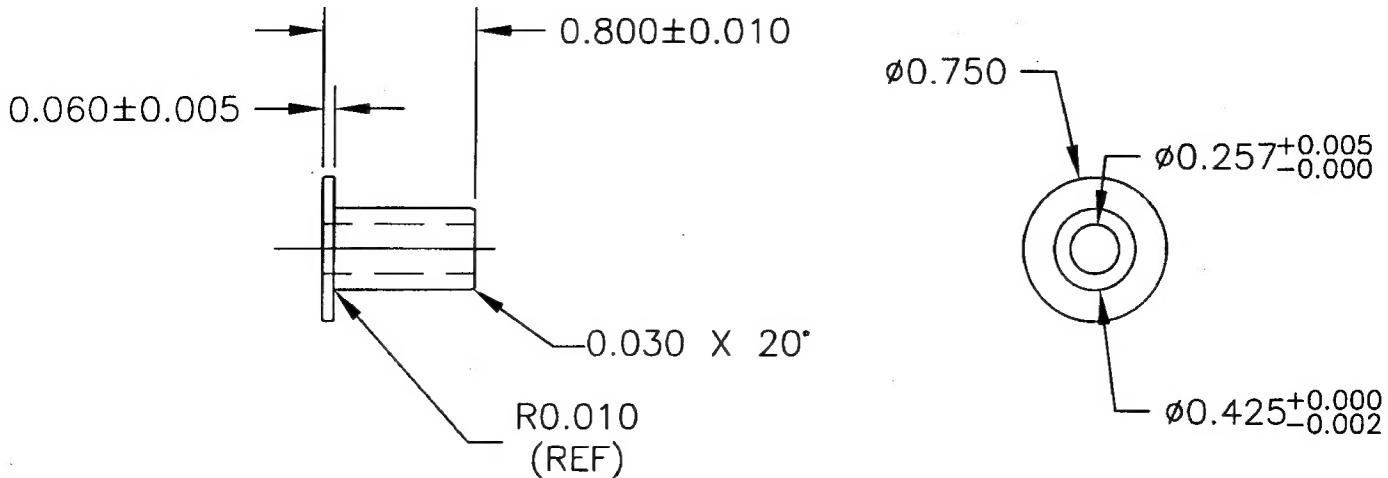
Measured by:	<u>RJ/S.P</u>	Audited by:	<u>SA</u>	Prototype Approval:	N/A
Date:	<u>07/08/08</u>	Date:	<u>07.08.08</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	PP

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DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2570	REV. B	SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE	1:1
A	96.09.16	NEW ISSUE		
B	07.04.17	UPDATE NOTES		

RELEASED
07.06.28 PH**D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. *33468*

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